

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004595**Date Inspected:** 28-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wang Sei Fa**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Panels**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 4 – OBG Sub Assembly

This QA Inspector observed ZPMC personnel performing Flux Cored Arc Welding (FCAW) and Shielded Metal Arc Welding (SMAW) of 89m strut mock up. Photographs have been filed below with this report.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of tower double diaphragm component weld designated as ESD1-SA411-2(1). In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) of tower double diaphragm component weld designated as SSD1-SA356. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

Bay 3 – OBG Sub Assembly

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Flux Core Arc Welding (FCAW) of welds to side plate designated as DP537-001 on Gantry. In process FCAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed continued Flux Core Arc Welding (FCAW) tack welding and fit-up of closed rib

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components to deck plates designated as: SP617-001, SP763-001, SP723-001, SP370-001, and SP315-001.

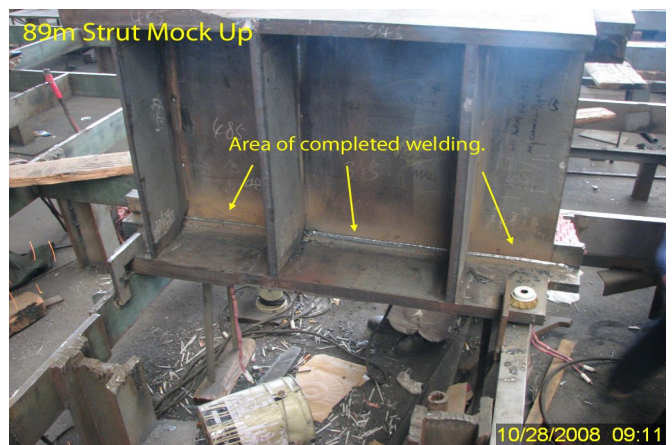
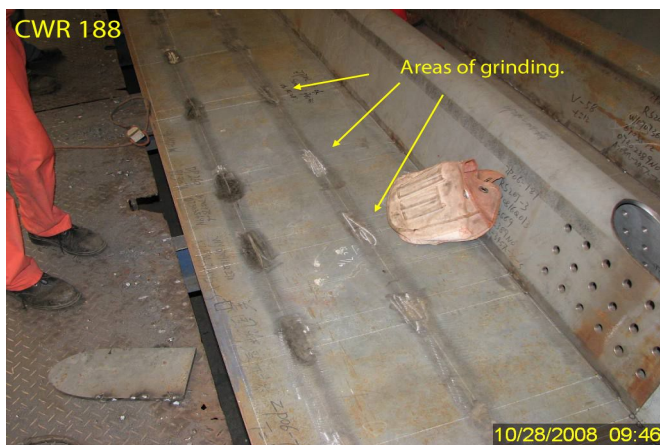
Bay 1 - OBG Sub Assembly

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Gas Metal Arc Welding (GMAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP395-001 on Gantry #1. In process GMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed ZPMC welding personnel performing automated, in gantry, Gas Metal Arc Welding (GMAW) of closed rib Partial Joint Penetration (PJP) welds to deck plate designated as DP368-001 on Gantry #2. In process GMAW appears to be progressing in compliance with Caltrans Engineer Approved welding procedure.

This QA Inspector observed continued Gas Metal Arc Welding (GMAW) tack welding and fit-up of closed rib components to deck plates designated as: DP152-001 and DP260-001.

This QA Inspector observed the grinding and Quality Control Magnetic Particle Testing (QCMT) of CWR 188 as performed by ZPMC personnel. ZPMC technicians performed MT of the areas that were ground after closed rib removal. ZPMC technicians mark 35 areas that contained rejectable MT indications. Repair was not performed at time of reporting. Photographs are filed below with this report.



Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford,William
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Quality Assurance Inspector

Reviewed By:	Cuellar,Robert
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QA Reviewer
